

Work Order ID 57630

April 12, 2010 11:35:28 AM

Page 1

Item ID: D2573

Accept

Revision ID:

Item Name: Saddle, Aft Out 205

Setup Start

Stop

Start Date: 16/04/2010 Start Qty: 8.00

Required Date: 23/04/2010 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference: *10-04-12*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2573

Rev E

100

0.00



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program Batch No. *DIP* Double check by: *KL* 11-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and insp

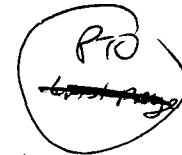
MUE

10/04/21

DIP
10/04/22

8

2



110

0.00



Mill Conv.

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine keyway as per dwg D2573 & D2574

MUE

10/04/21

DIP
10/04/22

8

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

MUE

10/04/21

DIP
10/04/22

8

PROGRAMED BY:

VERIFY BY:

QC APPROVED :

DART

DART AEROSPACE LTD

FOLIO #:

FA103

FOL REVISION:

PREPARED BY:

APPROVED BY:

CNC PROGRAM LOG

PART NUMBER: D2804-2

STA 155 BRACKET

REV: C

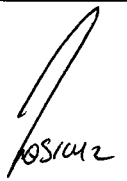

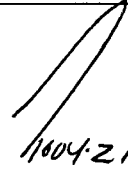
(SURFCAM 2004)

DSN/PATH FILE	NCC FILE	DESCRIPTION	HOLDER	TOOL	TH	SPEED	FEED	P	H# / L
PROGRAM # 5000 G54									
OPERATION # 2 (MILLING) TIME: 3:30 min									
DVA103AB02	A103AB05								
PVA103AB05.1	→	CENTER DRILL ALL HOLES	2	#4 - CENTER DRILL	20	1800	15.0	15.0	
PVA103AB05.2	→	DRILL 0.191 DIA HOLES	13	#11 DRILL	2	4210	6.3	6.3	
PVA103AB05.3	→	DRILL 0.507 DIA HOLE	1	15/32 - DRILL	3	1700	6.8	6.8	
PVA103AB05.4	→	CONTOUR 0.507 DIA LEAVE 0.002 ON SIDE (C-COMP ON)	7	3/8 - 1/32 RAD BULL	4	3200	10	10	
PVA103AB05.5	→	C' BORE DRILL 0.507 HOLE	7	3/8 - 1/32 RAD BULL	4	3200	10	10	
PVA103AB05.6	→	CONTO C' BORE 0.507 DIA LEAVE 0.002 ON SIDE (C-COMP ON)	7	3/8 - 1/32 RAD BULL	4	3200	10	10	
PVA103AB05.7	→	CONTOUR 0.757 DIA (C-COMP ON)	7	1/2 - 1/32 RAD INSERT	9	3600	10	10	
PVA103AB05.8	→								
PROGRAM # 6000 G56									
OPERATION # 3 (MILLING) TIME: _____									
DVA103AB02	A103AB06								
PVA103AB06.1	→	ROUGH LARGE POCKET LEAVE 0.125 SIDE	6	3/4 - ISCAR ROUGHER	6	8000	65.0	30.00	
PVA103AB06.2	→	ROUGH LARGE THRU POCKET	6	3/4 - ISCAR ROUGHER	6	8000	65.0	30.00	
PVA103AB06.3	→	ROUGH SMALL POCKET LEAVE 0.125 SIDE	7	1/2 - ISCAR ROUGHER	5	10000	65.0	25.0	
PVA103AB06.4	→	ROUGH SMALL THRU POCKET	7	1/2 - ISCAR ROUGHER	5	10000	65.0	25.0	
PVA103AB06.5	→	ROUGH CONTO LARGE POCK LEAVE 0.020 SIDE (C-COMP ON)	7	1/2 - ISCAR ROUGHER	5	10000	65.0	10.0	
PVA103AB06.6	→	FINISH INSIDE SMALL POCKET PROFILE (C-COMP ON)	7	1/2 - 1/16 RAD BULL	11	3820	20	15	
PVA103AB06.7	→	FINISH POCKET PROFILE (C-COMP ON)	7	1/2 - 1/8 RAD BULL	7	3820	30	10	
PVA103AB06.8	→	ROUGH OUTSIDE PROFILE LEAVE 0.020 ON SIDE (C-COMP ON)	6	1" - ROUGHER	10	6500	60.0	15	
PVA103AB06.9	→	FINISH OUTSIDE PROFILE (C-COMP ON)	7	1/2" - END MILL	18	3850	20.0	15	
PVA103AB06.10	→	FINISH THRU POCKETS	7	1/2 CARB E-MILL	18	3600	27.0	10.0	
PVA103AB06.11	→								

NOTE: USE DT8141 BASEPLATE ROUGH SIDE-UP FOR D2804-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2573 PAR #: _____ Fault Category: machined Parts NCR: (Yes) No DQA: _____ Date: 10/04/21
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 10/04/27

NCR: <u>57630</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/20	100	origin in "X" of 3 rd opp is off because origin was not well taken QC operator error		Scrap & replace in 46412 X 2	MUE 10/04/20	LA 10/04/24		

NOTE: Date & initial all entries

Work Order ID 57630

April 12, 2010 11:35:29 AM



Item ID: D2573

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Aft Out 205

Start Date: 16/04/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 23/04/2010 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

B.A 10/04/24

8

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

BR 10-4-26

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

7 Jul 10/04/26

(48)

Ø

Powder Coating

START TIME: 11:00am FINISH TIME: 11:30am OVEN TEMPERATURE: 320°F

PROGRAMED BY:

08/09/16

VERIFY BY:

QC APPROVED:

DART

DART AEROSPACE LTD

FOLIO #:

FA103

FOL REVISION:

PREPARED BY:

08/09/16

PART NUMBER: D2804-1/2 STA 155 BRACKET

REV: C (SURFCAM 2005V)

TOOL #	HOLDER TYPE #	DESCRIPTION	EXTEND OUT OF HOLDER
1			
2	13	#11 DRILL	
3	1	15/32 - DRILL	
4	7	3/8 - 1/32 RAD BULL	
5	7	1/2 - ISCAR ROUGHER	
6	6	3/4 - ISCAR ROUGHER	
7	7	1/2 - 1/8 RAD BULL	
8			
9	7	1/2 - 1/32 RAD INSERT	
10	6	1" - ROUGHER CARB 3FLT	
11	7	1/2 - 1/16 RAD BULL	
12			
13			
14			
15			
16			
17			
18	7	1/2" - END MILL CARB 2FLT	
19			
20	2	#4 - CENTER DRILL	
21			

Work Order ID 57630

April 12, 2010 11:35:29 AM



Page 3

Item ID: D2573

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle. Aft Out 205

Start Date: 16/04/2010 Start Qty: 8.00



Required Date: 23/04/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8

BR 10-4-26

170

Identify as per dwg & Stock Location: 431

0.00



Packaging

Memo

0.00

Packaging

10-4-26 8x SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27

ME 10-4-26

PROGRAMMED BY:

VERIFY BY:

QC APPROVED:

02/09/16

/ /

/ /

DART

DART AEROSPACE LTD

CNC PROGRAM LOG

FOLIO #:

FA103

FOL REVISION:

PREPARED BY:

M

08/09/16

PART NUMBER: D2804-1

STA 155 BRACKET

REV: C

(SURFCAM 2005V)

DSN/PATH FILE	NCC FILE	DESCRIPTION	HOLDER	TOOL	TH	SPEED	FEED	P	H# / L
PROGRAM # 2000 G54									
OPERATION # 2 (MILLING) TIME:									
DVA103AB01	A103AB02								
PVA103AB02.2	→	CENTER DRILL ALL HOLES	2	#4 - CENTER DRILL	20	10000	30	25	
PVA103AB02.3	→	DRILL 0.191 DIA HOLES	13	#11 DRILL	2	8000	24	24	
PVA103AB02.4	→	DRILL 0.507 DIA HOLE	1	15/32 - DRILL	3	2200	16	16	
PVA103AB02.5	→	CONTOUR 0.507 DIA LEAVE 0.002 ON SIDE (C-COMP ON)	7	3/8 - 1/32 RAD BULL	4	3200	10	10	
PVA103AB02.6	→	C BORE DRILL 0.507 HOLE	7	3/8 - 1/32 RAD BULL	4	3200	10	10	
PVA103AB02.7	→	CONTOUR C' BORE 0.507 DIA LEAVE 0.002 SIDE (C-COMP ON)	7	3/8 - 1/32 RAD BULL	4	3200	10	10	
PVA103AB02.8	→	CONTOUR 0.757 DIA (C-COMP ON)	7	1/2 - 1/32 RAD INSERT	9	3600	10	10	
PROGRAM # 3000 G54									
OPERATION # 3 (MILLING) TIME:									
DVA103AB01	A103AB03								
PVA103AB03.1	→	ROUGH LARGE POCKET LEAVE 0.125 SIDE	6	3/4 - ISCAR ROUGHER	6	8000	65.0	30.00	
PVA103AB03.2	→	ROUGH LARGE THRU POCKET	6	3/4 - ISCAR ROUGHER	6	8000	65.0	30.00	
PVA103AB03.3	→	ROUGH SMALL POCKET LEAVE 0.125 SIDE	7	1/2 - ISCAR ROUGHER	5	10000	65.0	25.0	
PVA103AB03.4	→	ROUGH SMALL THRU POCKET	7	1/2 - ISCAR ROUGHER	5	10000	65.0	25.0	
PVA103AB03.5	→	ROUGH CONTO LARGE POCK LEAVE 0.020 SIDE (C-COMP ON)	7	1/2 - ISCAR ROUGHER	5	10000	65.0	10.0	
PVA103AB03.6	→	FINISH INSIDE SMALL POCKET PROFILE (C-COMP ON)	7	1/2 - 1/16 RAD BULL	11	3820	20	15	
PVA103AB03.7	→	FINISH POCKET PROFILE (C-COMP ON)	7	1/2 - 1/8 RAD BULL	7	3820	30	10	
PVA103AB03.8	→	ROUGH OUTSIDE PROFILE LEAVE 0.020 ON SIDE (C-COMP ON)	6	1" - ROUGHER	10	6500	60.0	15	
PVA103AB03.9	→	FINISH OUTSIDE PROFILE (C-COMP ON)	7	1/2" - END MILL	18	3850	20.0	15	
PVA103AB03.10	→	FINISH THRU POCKETS	7	1/2 CARB E-MILL	18	3600	27.0	10.0	
PVA103AB03.11	→								

NOTE: USE DT8141 BASEPLATE MACHINE SIDE-UP FOR D2804-1

Picklist Print

April 12, 2010 11:35:27 AM

Page 1

Work Order ID: 57630

Parent Item: D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 16/04/2010

Required Date: 23/04/2010

Comments: IPP: 1 As Per RevE 06-01-27 JLM

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	51.0000	8.0000			



Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT42

46412

51

51

10 JTP 10/04/22

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™

DART AEROSPACE LTD	Work Order:	57630
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	0.440	0.441		
B	1.745	1.755		1.747	1.747	1.750	1.750		
C	3.495	3.505		1.500	1.500	1.500	1.500		
D	1.745	1.755		1.747	1.747	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		.497	.498	0.497	0.5005		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.4985	.500	.501	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.563	.566	.566	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.369	1.370	1.369	1.369		
N	2.495	2.505		2.497	2.499	2.499	2.499		
O	4.119	4.129		4.122	4.123	4.122	4.122		
P	0.115	0.135		.126	.126	.127	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.254	.254	.253		
S	0.115	0.135		.128	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.229	3.232	3.230	3.230		
V	0.230	0.250		.238	.238	.239	.237		
W	0.115	0.135		.129	.129	.125	.130		
X	0.308	0.313		.310	.310	0.311	0.311		
Y	0.760	0.765		.764	.763	0.764	0.764		
Z	0.352	0.372		.364	.365	0.366	0.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	.630	0.628	0.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.516	1.518	1.518	1.516		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.275	.275	.275		
AH	0.240	0.260		.247	.251	.250	.249		
AI	2.000	2.020		2.004	2.004	2.008	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>mw</i>
Date: <i>10/04/20</i>

Audited by: <i>K.A</i>
Date: <i>10/04/24</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to $\varnothing 0.312$ "

7-Drill holes for wearplates using DT 8028-5. Open to $\varnothing 0.297$ ".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to $\varnothing 0.625$ " as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skid tube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

DART AEROSPACE LTD	Work Order:	57630
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443		0.441	0.441	0.441	0.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.007	8.006		
F	0.490	0.510		0.500	0.501	0.501	0.502		
G	0.257	0.262		0.260	0.260	0.260	0.260		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.503	0.502	0.500	0.503		
J	1.174	1.184		1.178	1.178	1.179	1.179		
K	0.558	0.578		0.571	0.570	0.568	0.571		
L	1.174	1.184		1.178	1.178	1.179	1.179		
M	1.365	1.375		1.369	1.369	1.370	1.370		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.122	4.122	4.124	4.124		
P	0.115	0.135		0.126	0.125	0.125	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.255	0.254	0.255	0.255		
S	0.115	0.135		0.130	0.131	0.130	0.131		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.229	3.230	3.230		
V	0.230	0.250		0.240	0.2405	0.240	0.238		
W	0.115	0.135		0.130	0.128	0.129	0.130		
X	0.308	0.313		0.3105	0.310	0.310	0.310		
Y	0.760	0.765		0.7604	0.762	0.762	0.762		
Z	0.352	0.372		0.363	0.363	0.365	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.624	0.630	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.250	0.250	0.250		
AE	1.500	1.520		1.5145	1.5155	1.515	1.514		
AF	0.115	0.135		0.125	0.125	0.125	0.125		
AG	0.240	0.280		0.260	0.265	0.255	0.25		
AH	0.240	0.260		0.249	0.249	0.249	0.248		
AI	2.000	2.020		2.004	2.0055	2.005	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.03		
Accept/Reject									

Measured by:	mmj
Date:	10/04/24

Audited by:	HA
Date:	10/04/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod _____

4-Grind weld flush to cap on top surface only.

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to $\varnothing 0.312$ "

7-Drill holes for wearplates using DT 8028-5. Open to $\varnothing 0.297$ ".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to $\varnothing 0.625$ " as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skid tube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: _____ Time: _____

Finish Date: _____ Time: _____

A/R Sikaflex-291 _____

Sikaflex expiry date: _____ -Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod _____

05.17.61